

**Work Order ID 86539****\*86539\***

Page 1

Wednesday, July 04, 2012 4:10:02 PM

Item ID: D3916-041

Accept:

**\*N900040100\***Setup: Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib Assembly

Start Date: 7/4/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals: Process Plan: *MF*Date: *12-07-04*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3916	A

100

0.00

**\*100\***

Large Fab

Memo

0.00

Large Fab

1- Cut tube 50"  
2- Bend tube with manuel pipe bender as per DT9567  
\*\*\* Make line at 9.00" and use jig for other lines, and ensure seam in place on side of tube when bending\*\*\*  
3- Trim access tube material to finish size as per dwg D3916  
4- Drill and chamfer holes as per dwg D3916-1 using DT9605

*(6) SMO 12-07-16*

105

QC6- Inspect dimensions to drawing

0.00

**\*105\***

QC

Memo

0.00

Quality Control

*12-07-16*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 86539

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**\*86539\***

Page 2

Item ID: [D3916-04]

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Rib Assembly

Start Date: 7/4/2012 Start Qty: 6.00 **\*6\***

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 6.00 **\*6\***

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start **\*NR1\***

QC: Date:

SPC (Y/N): Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

107

Weld per dwg A/R S.S. rod Batch: M121602 0.00

**\*107\***

Large Fab

Memo

0.00

Large Fab

1- weld bushing as per dwg D3916  
2- grind welds flush

Pl 1cc 12-7-12

110

QC5- Inspect part completeness to step on W/O 0.00

**\*110\***

QC

Memo

0.00

Quality Control

DAS  
16  
2-2

7/10/12

6x

12-07-12

120

QC10- Inspect visual per QSI004- ground welds 0.00

**\*120\***

QC

Memo

0.00

Quality Control

DAS  
16  
2-2

7/10/12

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**Work Order ID 86539**

Wednesday, July 04, 2012 4:10:02 PM

**\*86539\***

Page 3

Item ID: D3916-041

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Rib Assembly

Stop

**\*NS2\***

Start Date: 7/4/2012 Start Qty: 6.00

**\*6\***

Cust Item ID:

Required Date: 7/11/2012 Req'd Qty: 6.00

**\*6\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Identify as per dwg &amp; Stock Location: \_\_\_\_\_

0.00

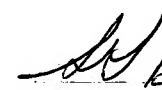
**\*130\***

Packaging

Memo

0.00

Packaging

 12-07-19

140

QC21- Final Inspection - Work Order Release

0.00


**\*140\***

QC

Memo

0.00

Quality Control

12/17/23 MEF  
12-07-20

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Wednesday, July 04, 2012 4:10:02 PM

Page 1

Work Order ID: 86539

Parent Item: D3916-041

Parent Item Name: Rib Assembly

Start Date: 7/4/2012

Required Date: 7/11/2012

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP RevA: New issue DD verified by:EC  
verified by:EC

IPP Rev:B as per dwg revA 10.03.15

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3759-1 Bushing		Manufactured	No			100	Each	170.0000	7	42		12-7-18	

Location

Loc Qty

Loc Code

WA

163

79213

1

83464

162

WA005

7

66489

1

82785

6

M304TS0.750W.049

Purchased

No

304 SQ Tube .75x.75x.049W

100

f

158.6697

4.166

26,311,579

12-07-16

Location

Loc Qty

Loc Code

MAT017

37.756337

121898

37.756337

MAT018

119.8508959

119147

2

119643

3.30639585

121439

16.8353

122201

97.7092

WA034

1.0625

121087

1.0625

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

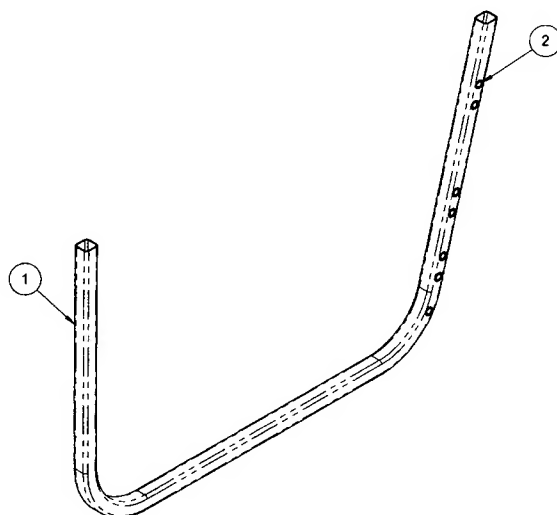
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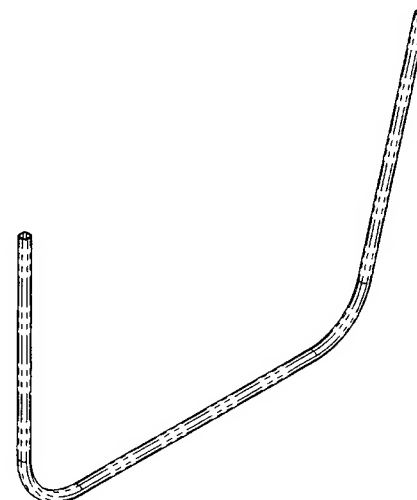
**NOTE:** Date & initial all entries



ITEM	QTY -041	P/N	DESCRIPTION
	X	D3916-041	RIB ASSY
1	1	D3916-1	RIB
2	7	D3759-1	BUSHING



**D3916-041 RIB ASSY**



**D3916-5 LIGHT RIB**

#86539

OL 10.12.21  
 UNDER REVIEW  
 ADDITION OF HOLE + BUSHING  
 ON D3916-041-1 RIBS.

**RELEASED**  
 2010-03-12  
 JWP

A	NEW ISSUE		JPH	10.03.04
REV.		DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>		
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA		
CHECKED	JPH	DRAWING NO.	REV. A	
MFG. APPR.	JPH	D3916	SHEET 1 OF 4	
APPROVED	JPH	TITLE	SCALE	
DE APPR.	JPH	RIB ASSY, 350 BASKET	NTS	
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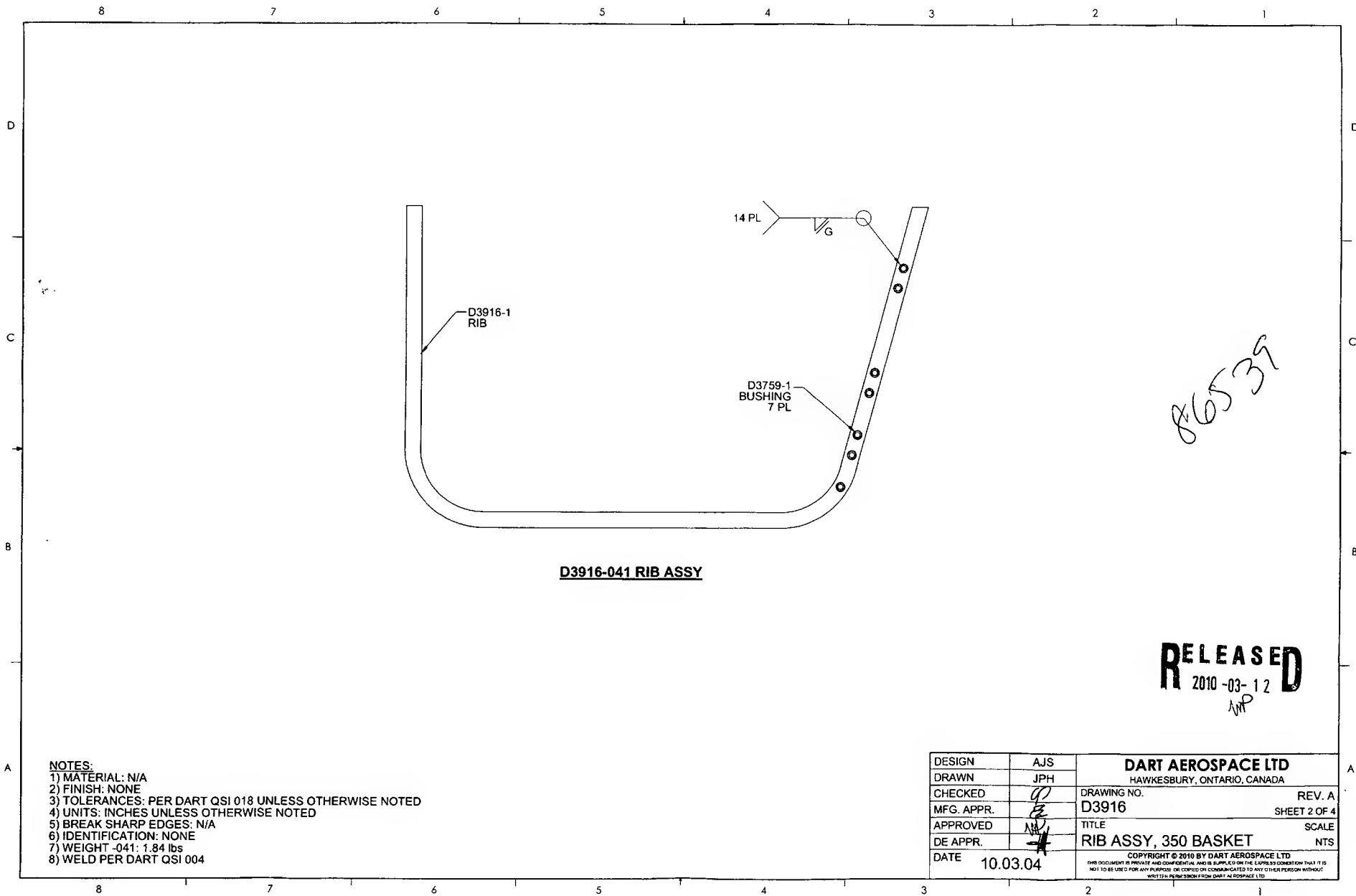
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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# Dart Aerospace Ltd

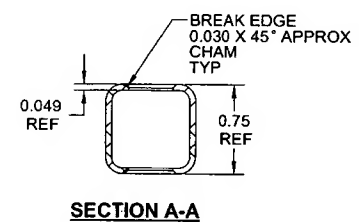
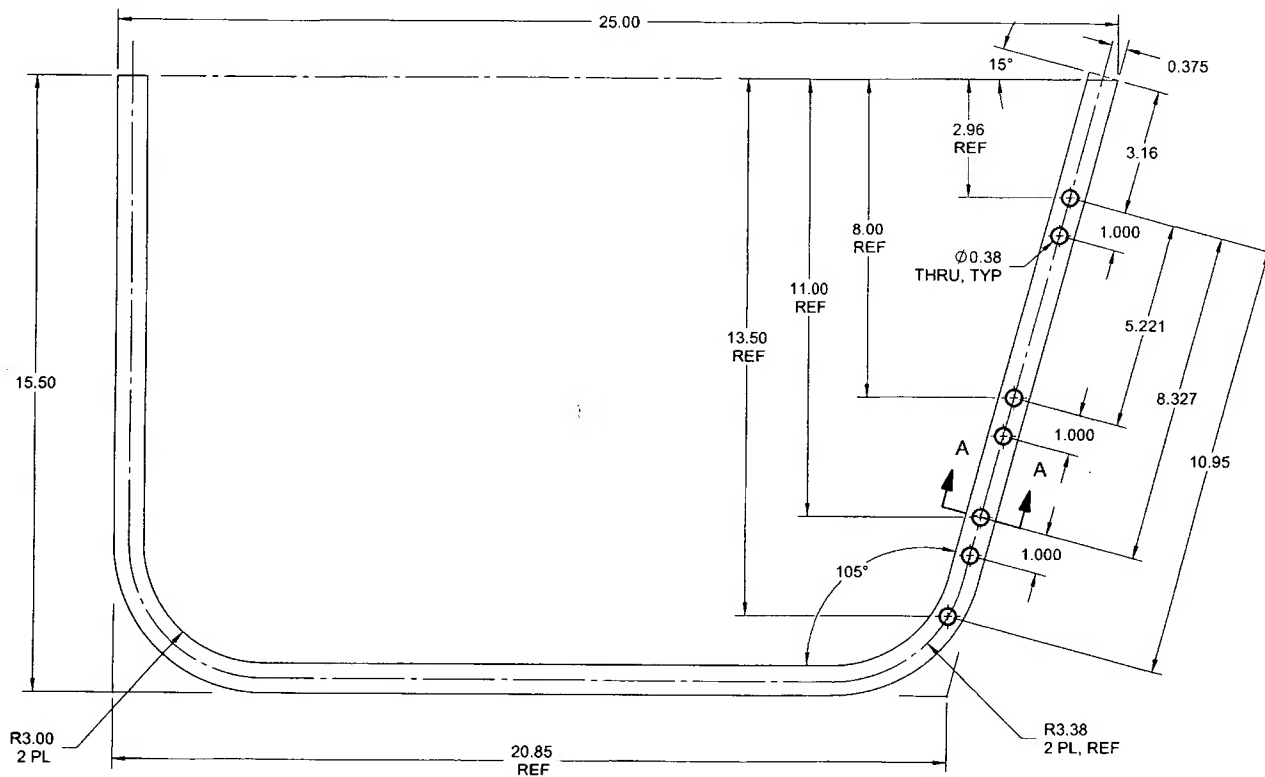
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**NOTE:** Date & initial all entries



#86539

9 D3916-1 RIB

RELEASED  
2010-03-12  
NPA

# NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.049 WALL  
REF DART SPEC. M304TS0.750W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.76 lbs
- 9) TUBE FLAT LENGTH 50.0 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 3 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	RIB ASSY, 350 BASKET	NTS
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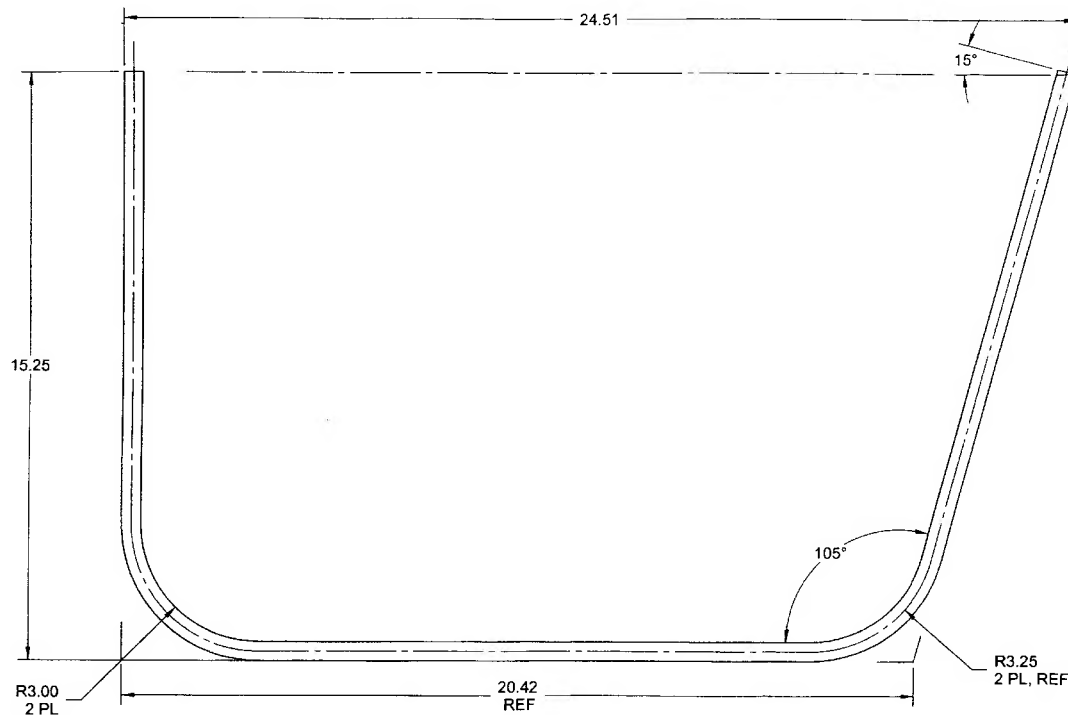
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



9 D3916-5 LIGHT RIB

RELEASED  
2010-03-12

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.50 X 0.50 X 0.049 WALL  
REF DART SPEC. M304TS0.500W.049
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.07 lbs
- 9) TUBE FLAT LENGTH 49.5 REF

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D3916	SHEET 4 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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